

Work Order ID 61711

Page 1

Tuesday, August 31, 2010 1:53:43 PM

Item ID:	D3793-3	Accept		Setup	Start	
Revision ID:						
Item Name:	Wearshoe				Stop	
Start Date:	8/31/2010	Start Qty: 10.00		Cust Item ID:		
Required Date:	9/7/2010	Req'd Qty: 10.00		Customer:		
Reference:						
Approvals:	Process Plan:	Date: 10-8-81	Tooling:	Date:	Run	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3793	Rev A								
100 	FLOW WATER JET Waterjet FLOW CNC Waterjet 344.040	0.00							10-9-8
	Memo 1-Cut as per Dwg D3793 Dwg Rev: Prog Rev: 2-Deburr if necessary	0.00							
110 	QC2- Inspect parts off machine FAI/FAIB QC Quality Control	0.00							10-9-8
	Memo	0.00							
120 	QC8- Inspect parts - second check QC Quality Control	0.00	5 10/09/01						10-9-8
	Memo	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3793-3

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 8/31/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Brake NC

Operation
Description

NC BRAKE

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Brake NC

Brake NC

Memo

0.00

SP 10/09/09

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 10/09/09

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

10/09/10

Memo

0.00

START TIME: 10:20
OVEN TEMPERATURE: 320
FINISH TIME: 10:50

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D3793-3

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 8/31/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Tool ID

M

Tool #

10/6/13

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



Packaging

Packaging

Identify as per dwg & Stock Location:

FP-18

0.00

BR 10-9-13.

12

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/6/14

BR 10-9-13

12

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, August 31, 2010 1:53:47 PM

Page 1

Work Order ID: 61711



Parent Item: D3793-3



Parent Item Name: Wearshoe

Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No		100	sf	111.7987	1.2828	13.50316	15.4		

304/316 .040 Sheet



Location	Loc Qty	Loc Code
MAT	16.1522	
114574	16.1522	
MAT20	95.6465	
112885	2.7475	
113062	0.699	
115440	92.2	

115440

(12)

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DART AEROSPACE LTD	Work Order:	61711
Description: Wearshoe	Part Number:	D3793-3
Inspection Dwg: D3793	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>B</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: 10-9-09	Date: 10/09/09		Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	

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SHC
RETURN TO
ENGINEERING
UNCONTROLLED

SUBJECT TO AMENDMENT

WITHOUT NOTICE

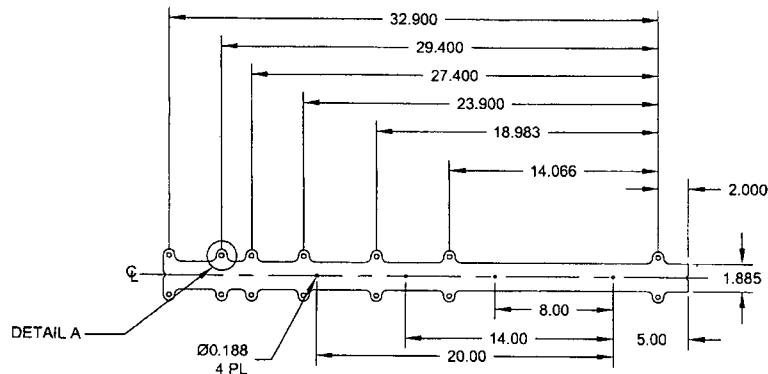
WORK ORDER

NO. 16711

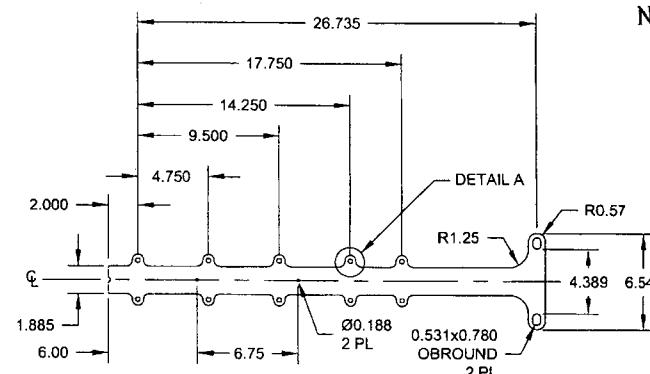
BS10-8-9

8 7 6 5 4 3 2 1

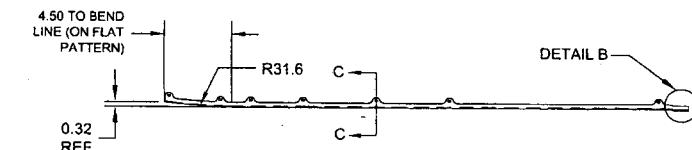
D C B A 1 2 3 4 5 6 7 8



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

8 7 6 5 4 3 2 1

D C B A 1 2 3 4 5 6 7 8

A	NEW ISSUE	PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	PH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.05.14	SCALE	NTS

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3793 SHEET 1 OF 2

TITLE WEARSHOE

REV. A

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*RELEASED
08.05.23/14*

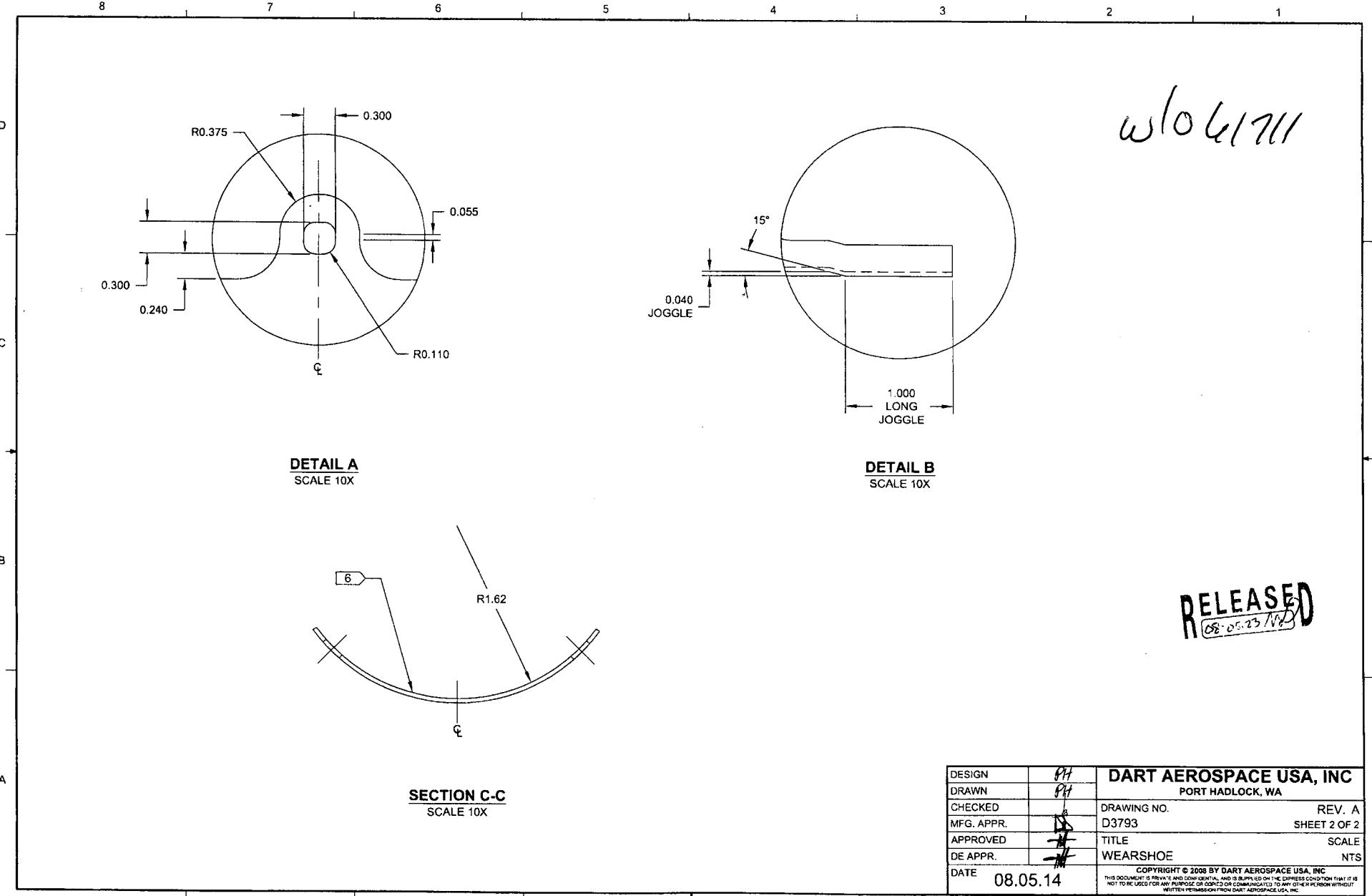
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DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO. D3793	
MFG. APPR.	PH	REV. A	
APPROVED	PH	SHEET 2 OF 2	
DE APPR.	PH	TITLE WEARSHOE	
DATE	08.05.14	SCALE NTS	

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